

8990 ←

→ D4001-3

Work Order ID 55896

February 4, 2010 8:31:33 AM



Page 1

Item ID: D4001-7

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Bulkhead Fitting

Stop



Start Date: 2/04/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-204

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4001	A-PRELIM PAT Rev.A	10-06-10							

100		0.00							
-----	--	------	--	--	--	--	--	--	--

Lathe Conv	Memo	0.00							
------------	------	------	--	--	--	--	--	--	--

Conventional Lathe	Turn fitting as per Dwg		2						
--------------------	-------------------------	--	---	--	--	--	--	--	--

Deburr

→ 10/02/09

110		0.00							
-----	--	------	--	--	--	--	--	--	--

QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
----	---	------	--	--	--	--	--	--	--

→ 10/02/09

0.00			2						
------	--	--	---	--	--	--	--	--	--

Quality Control	Memo	0.00							
-----------------	------	------	--	--	--	--	--	--	--

2			2						
---	--	--	---	--	--	--	--	--	--

120		0.00							
-----	--	------	--	--	--	--	--	--	--

QC	QC8- Inspect parts - second check	0.00							
----	-----------------------------------	------	--	--	--	--	--	--	--

→ 10/02/09

0.00			2						
------	--	--	---	--	--	--	--	--	--

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control		0.00							
-----------------	--	------	--	--	--	--	--	--	--

→ 10/02/09

(+2)

~~PRELIMINARY ISSUE~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55896

Page 2

February 4, 2010 8:31:33 AM

Item ID: D4001-*3*

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Bulkhead Fitting

Stop



Start Date: 2/04/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

*BR 10-02-9**(2)*

HandFinish

Memo

0.00

Hand Finishing

Brush alodine as per Dwg

Scotch Brite machined surface prior to Alodine

140

QC3- Inspect Part Finish

0.00

*W 10-01-69**(2) J*

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00

10-6-15 (2) sf

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55896

Page 3

February 4, 2010 8:31:33 AM

Item ID: D4001-X3

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Bulkhead Fitting

Stop



Start Date: 2/04/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

10/06/15 JJ

QC

Quality Control

Memo

0.00

R00-219
(2)

POSITIVE RECALL
 EFFECTIVE 10-02-04 AUTH [Signature]
 RELEASED [Signature] DATE 10-06-10

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 4, 2010 8:31:37 AM

Page 1

Work Order ID: 55896



Parent Item: D4001-~~3~~



Parent Item Name: Fuel Filler Bulkhead Fitting

Start Date: 2/04/10

Required Date: 2/11/10

Comments: Ipp Rev:A New Issue 10-02-03 JLM Verified By:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN832-6D		Purchased		No		100	Each	10.0000	2.1053			



UNION

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	10
107737	9
16323	1

10

9

1

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55846
Description: Fuel Filter Bulkhead fittings	Part Number:	14001-X-3
Inspection Dwg: 5001-X Rev: A Date: 02/1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SA</u>	Audited by:	<u>f</u>	Prototype Approval:	N/A
Date:	10/02/09	Date:	10/02/09	Date:	N/A

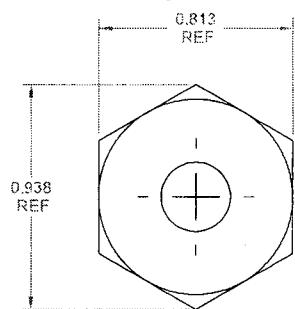
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

J. Pen Rev. 1
10-06-10

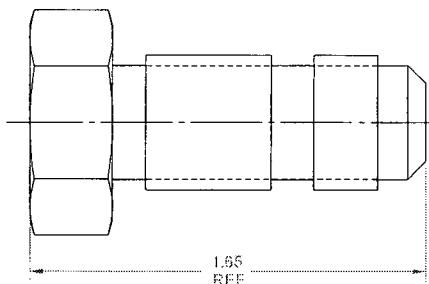
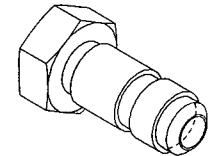
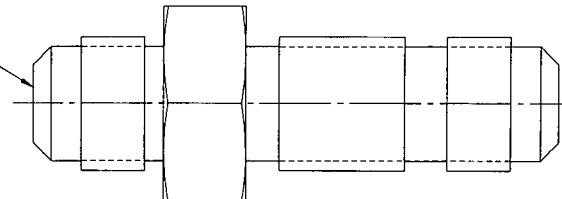
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-7	JCA-M47-2-28 (AN832-6D-JCA)

No alt x2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35896
BT 10-2-04



AN832-6D
BEFORE MODIFICATION
REF



new - 3 J see rev. A

D4001-7 FUEL FILLER BULKHEAD FITTING

PRELIMINARY ISSUE

09.10.14

NOTES:

- 1) MATERIAL: MADE FROM AN832-6D ✓
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-7" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs

DESIGN	DRAWN	DART AEROSPACE LTD
CHECKED	REV. PA1	HAWKSLEY, ONTARIO, CANADA
MFG. APPR.	D4001	SHEET 2 OF 2
APPROVED		SCALE
DE APPR.		NTS
DATE	09.10.14	FITTING

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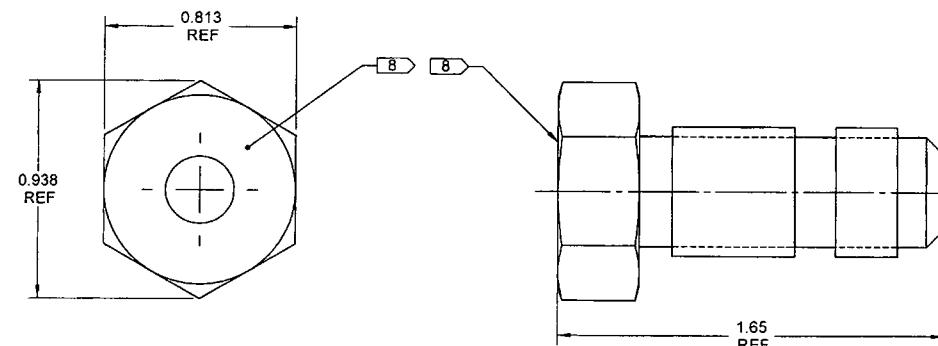
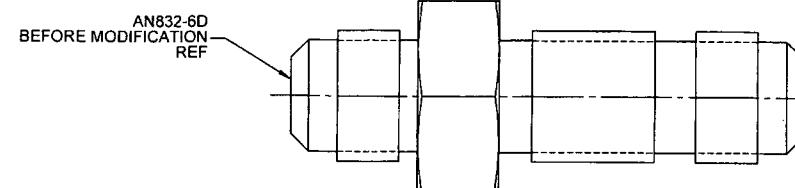
4

3

2

1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
*D4001-3	JCA-M47-2-28 (AN832-6D-JCA)

D4001-3 FITTING

RELEASED
2010-05-05
WTO-5586

- NOTES:
- 1) MATERIAL: MADE FROM AN832-6D
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.04 lbs
 - 8) BRUSH ALODINE MACHINED SURFACE

DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	
MFG. APPR.	<i>BS</i>	REV. A	
APPROVED	<i>BS</i>	D4001	
DE APPR.	<i>BS</i>	SHEET 2 OF 2	
DATE	10.02.05	TITLE	SCALE
		FITTING	NTS

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A

D

C

B

A